


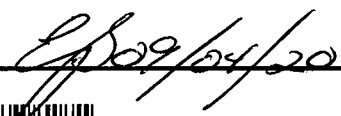







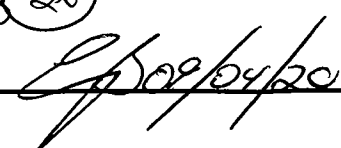


Date: Monday, 20/04/2009 9:59:24 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BATTERY LOCK ASSEMBLY
Job Number : 47278	
Estimate Number : 10900	
P.O. Number :	Part Number : D3393041
This Issue : 20/04/2009 S.O. No. :	Drawing Number : D3393 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 45559	Material : N/A
Written By :	Due Date : 27/04/2009 Qty: 3 Um: Each
Checked & Approved By : <u>JULIE DAWSON 04.20</u>	
Comment : Est Rev:A New Issue 05-11-22 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0 D27287	Dart Logo label
	
	
Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)	
Pick:	
Qty Part Number	Description Batch
1 D2728-7	Decal <u>622554</u>
	
2.0 D33731	Cam Lock
	
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)	
Pick:	
Qty Part Number	Description Batch
1 D3373-1	Cam Lock <u>644105</u>
CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE	
3.0 516WC	SS Flat Washer 5/16
	
	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)	
Pick:	
Qty Part Number	Description Batch
2 5/16WC	SS Flat Washer <u>M103165</u>
	
4.0 D33931	Battery Lock Casing
	
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)	
Pick:	
Qty Part Number	Description Batch
1 D3393-1	Battery Lock Casing <u>B38333</u> (20)
	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 9:59:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 47278

Part Number: D3393041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

D33933

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

044108

EP 09/04/20

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

A/RN/A262 Locktite

M109985

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

Key Numbers

1- C420A

5- _____

2- C420A

6- _____

3- C420A

7- _____

4- _____

8- _____

EP 09/04/20 (3)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number

Description

Batch

A/R N/A

SS Rod

M106762

EP 09.04.20

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 47278

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-04-23

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Apply Crazy Glue to cap and press into Body
9567K21 Batch: M110822

EP09/04/24 (3)

10.0

9567K21

Polyethelene Cap



Comment: Qty: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)
Polyethelene Cap M110822

EP09/04/24

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/24 (X3)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST486

X3=C420A

8809/04/24 (X3)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/27

Job Completion



C420A

MF 09-04-24

W/O:		WORK ORDER CHANGES					
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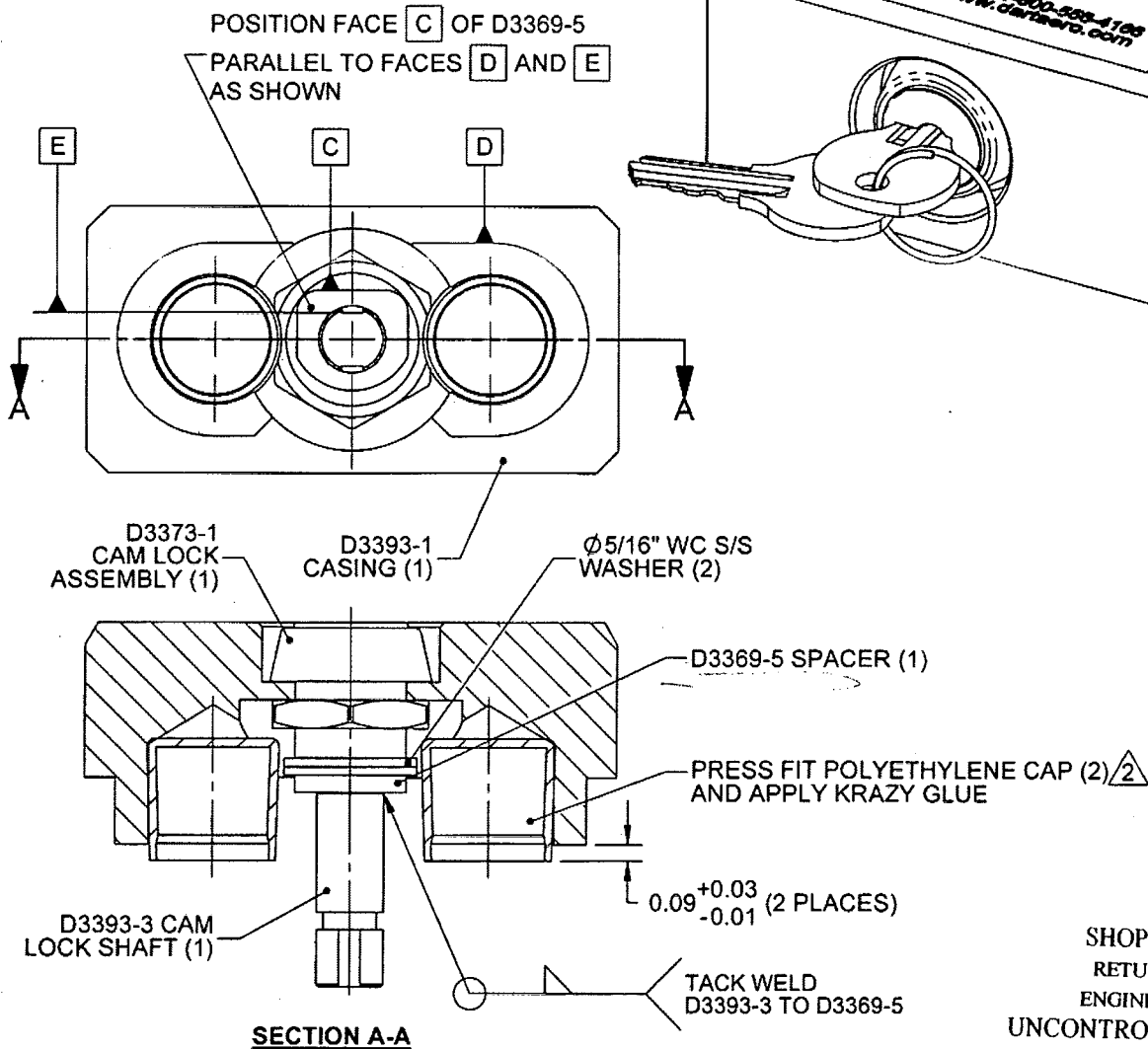
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED AKS	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
05/03/09D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

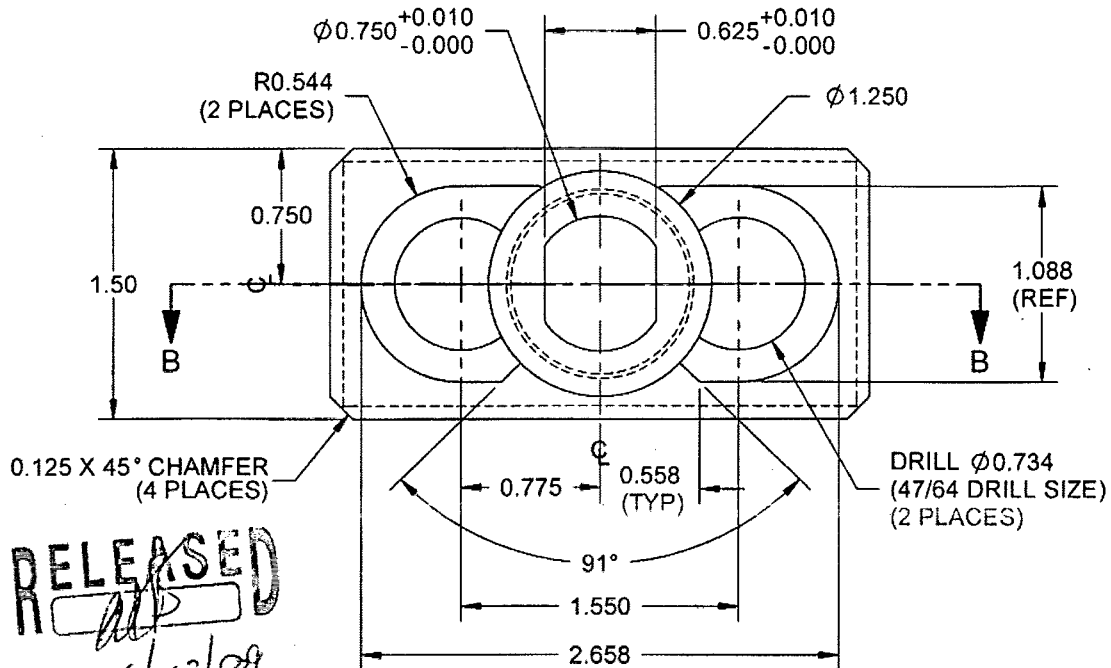
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WORK ORDER
NO. 47278

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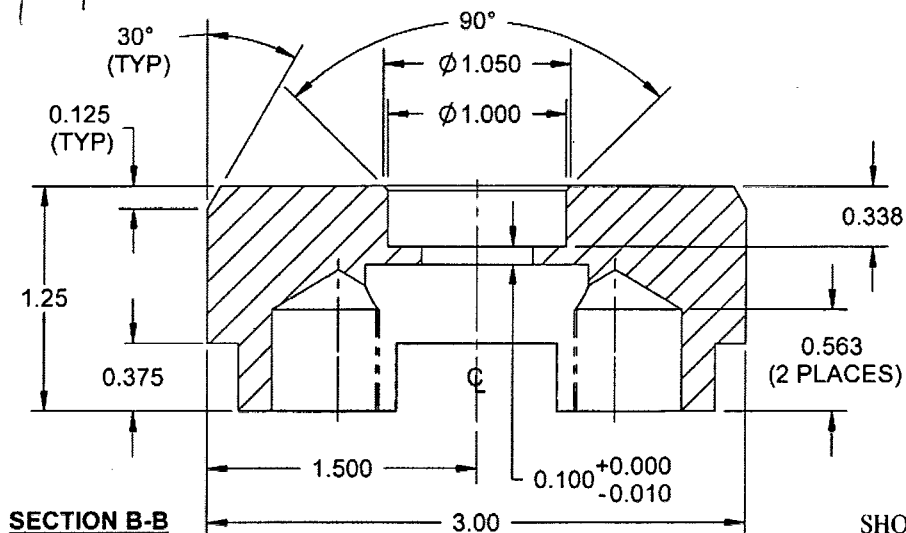
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CHECKED FF	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



RELEASED
05/03/09

**SECTION B-B****D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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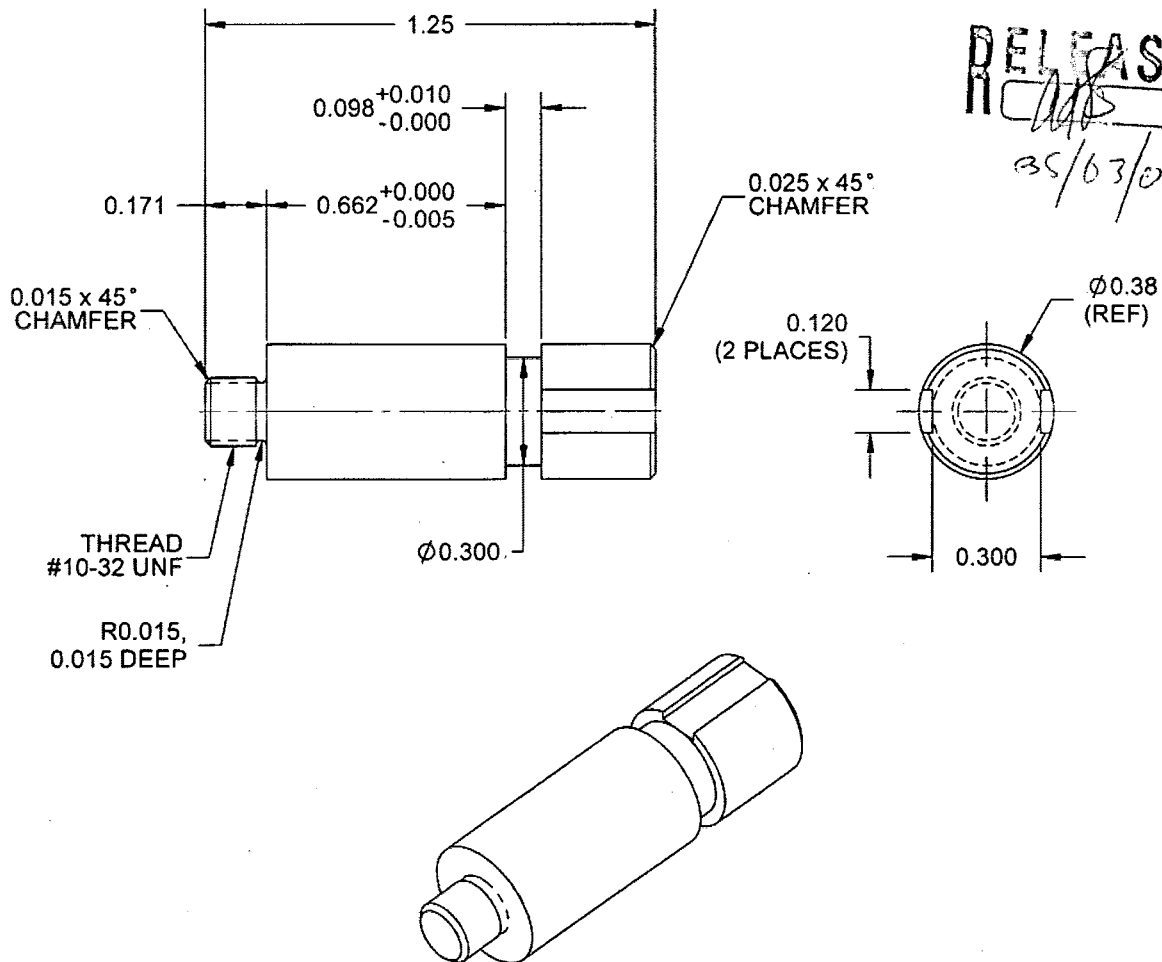
WORK ORDER

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CHECKED <i>J.F.</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1

**D3393-3 CAM LOCK SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. *47228*

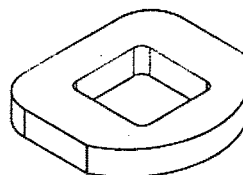
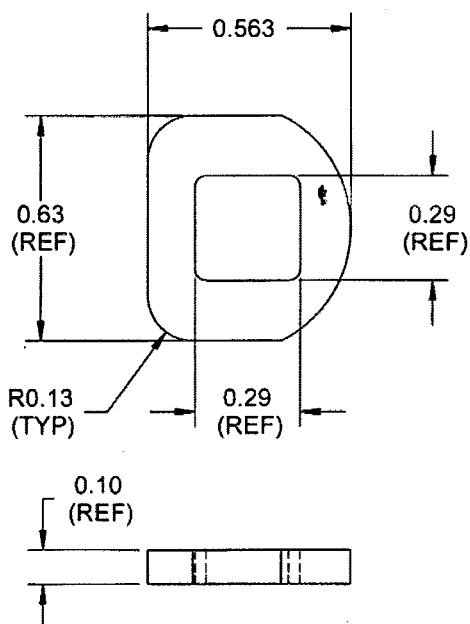
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11

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WITHOUT NOTICE
WORK ORDER
NO. 41278

- 5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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